DEC STD 092-8 Finish and Color Standard— Touch-Up and Repair Procedures

DOCUMENT IDENTIFIER: A-DS-EL00092-08-0000 Rev B, 22-May-1992

ABSTRACT: This document contains a list of approved touch-up specifications for finishes on Digital hardware.

APPLICABILITY: The specifications listed in this standard describe touch-up procedures for Digital internal use only at assembly, rework, and refurbishing. The procedures are not intended for use by Digital hardware suppliers unless specified by Digital.

STATUS: APPROVED 22-May-1992; use VTX SMC for current status.

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REVISION HISTORY:	Rev A,	15-May-1991	
	REV B,	22-May-1992	ECO Number NRO01

Document Management Category:	Paints and Finishes (HPF)
Responsible Department:	Systems Materials Engineering
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APPROVAL: This document has been reviewed and recommended for approval by the General Review group for its category and the DEC STD 092-8 Advisory Committee.

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1 PURPOSE

This document describes procedures for Digital internal use only to touch-up or repair a product's finish at assembly, rework, and refurbishing. These procedures are designed for the specific intentions listed in each individual specification. The procedures are not a supplement for poor quality, inferior, inadequate, or corroded finishes.

NOTE

These specifications do not list all of the intended uses of the touch-up and repair procedures, nor do they list all of the material property differences between the original finish and the applied touch-up material.

1.1 APPROVAL

Use of any touch-up or repair procedure on a specific product requires proper Digital engineering approval. This approval must be documented.

1.2 QUALITY

These touch-up and repair finishes do not have functional or aesthetic properties equivalent to the original specified finishes.

Touched-up or repaired parts must exhibit good workmanship and must comply with *DEC STD 092-1 Finish and Color Standard - Finish Standard for Applicators*. The final part must meet the quality level specified in the appropriate Approved Finish specification or part drawing. The final part must also meet all of the requirements listed in the appropriate Touch-Up specification.

2 DOCUMENT IDENTIFIER

Each specification has a unique document identifier assigned in accordance with *DEC STD 012-1 Documentation Identification Conventions Including Mnemonic Codes*. Figure 1 illustrates the document identifier format for touch-up specifications.

Media/Size code – All original Standards and Methods Control (SMC) documents are code *A* which indicates that the original information is documented on 8 1/2 $\times$ 11 inch paper.

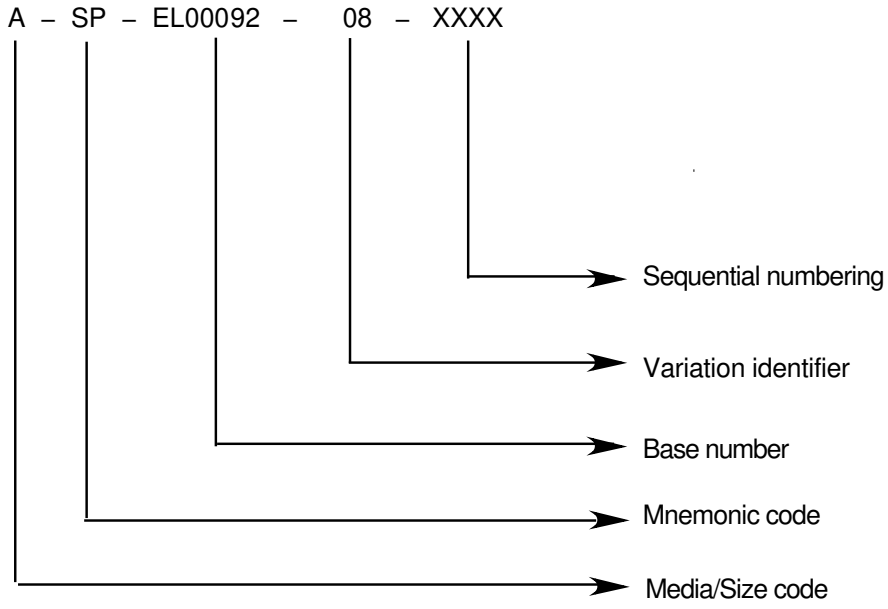
Mnemonic Code – The 2-character mnemonic code indicates that the document is a specification.

Base Number – The base number is a 7-character alphanumeric field; all documents produced and controlled by SMC use EL for the first 2 characters. The next 5 characters indicate the Digital standard preceded by zeros to complete the field.

Variation Identifier – The variation identifier is a 2-character numeric field that follows the base number. It identifies the individual section of a Digital standard.

Sequential Numbering– The 4-character numeric field is assigned to new touch-up specifications as the specifications become available.

Figure 1: Document Identifier Format for Touch-Up Specifications



NOTE

The media/size code, mnemonic code, and the first four characters of the base number may be omitted when specifying the touch-up specification.

3 SPECIFYING TOUCH-UP OR REPAIR PROCEDURES

Digital finish touch-up procedure specifications identify the procedures and approved materials acceptable for the repair of Digital products. These specifications provide the Digital touch-up number, a description of the touch-up's purpose, a repair procedure, a list of approved materials, and the quality criteria.

A touch-up or repair procedure must be specified in the following way:

1. The desired touch-up is specified by the specific touch-up number. Refer to Table 1 for a listing of all available touch-up specifications. If necessary, refer to Table 2 for a cross-referenced listing.
2. The desired level of touch-up must also be specified. Refer to the individual touch-up specification for an explanation of the levels.

Each section of Table 1 refers to a type of finish. Within the appropriate section, locate the necessary touch-up procedure and obtain a copy of the touch-up specification listed.

Table 1: Touch-Up Specifications Listed by Type of Finish

Touch-Up Specification Number	Touch-Up Specification Title
	Paint
092-08-0001	Touch-Up Procedure for Air Dry and Aerosol Paints
	Plating
092-08-0002	Touch-Up Procedure for Zinc Plate and Clear or Blue Bright Chromate
092-08-0003	Touch-Up Procedure for Nickel Plating
092-08-0004	Touch-Up Procedure for Zinc Plate and Yellow Chromate
092-08-0007	Touch-Up Procedure for Electroless Nickel Plating on Plastics
	Conversion and Oxide Coatings
092-08-0005	Touch-Up Procedure for Yellow Chromate on Aluminum
092-08-0006	Touch-Up Procedure for Clear Chromate on Aluminum

Table 2 shows a cross-referenced listing of Digital approved finishes and the corresponding touch-up specification number. The table lists one of three references for each finish type. The references are:

1. Specification Number— Lists an approved touch-up specification.
2. Blank space— Indicates an approved specification has not been developed.
3. *None*— It is not recommended that touch-up be used on this finish.

Table 2: Touch-Up Cross Reference List

Finish Number	Finish	Touch-Up Specification
	Paint	
092-A10X-XXX	Smooth Paint Finish	092-08-0001
092-A11X-XXX	Smooth Paint Finish	092-08-0001
092-A12X-XXX	Smooth Paint Finish	092-08-0001
092-A13X-XXX	Texture Paint Finish	092-08-0001
092-A14X-XXX	Texture Paint Finish	092-08-0001
092-A15X-XXX	Texture Paint Finish	092-08-0001
092-A16X-XXX	Hot Stamping - Plastic Substrates	None
092-A17X-XXX	Clear Hard Coat Finish	None
092-A18X-XXX	Screen/Pad Marking	None
092-A38X-XXX	Air Dry (Texture) Paint for Plastic	092-08-0001
092-A39X-XXX	Air Dry (Fine Texture) Paint for Plastic	092-08-0001
092-A40X-XXX	Surface Preparation Finish	None
092-A41X-XXX	Texture Paint Finish for Plastic Covers	092-08-0001
092-A42X-XXX	Fine Texture Paint Finish for Plastic and Metal Substrates	092-08-0001

Table 2 (Cont.): Touch-Up Cross Reference List

Finish Number	Finish	Touch-Up Specification
	Paint	
092-A43X-XXX	Paint Finish (Smooth) for Plastic	092-08-0001
092-A44X-XXX	Air Dry (Smooth) Paint for Plastic	092-08-0001
092-A45X-XXX	Epoxy Powder Coating (Black)	
092-A46X-XXX	Nylon Coating	
092-A47X-XXX	Epoxy Powder Coating	
092-A48X-XXX	Epoxy Powder Coating (Low Gloss Black)	
092-A60X-XXX	Urethane Coating for Magnets	
092-A65X-XXX	Black Conductive Nickel Paint	None
092-A66X-XXX	Copper Acrylic Conductive Paint	None
092-A70X-XXX	Black Conductive Paint for Metal Substrates	
	Metal Plating	
092-B04X-XXX	Zinc Plate with Blue Bright Chromate	092-08-0002
092-B05X-XXX	Zinc Plate with Yellow Chromate	092-08-0004
092-B06X-XXX	Zinc Plate with Yellow Chromate	092-08-0004
092-B07X-XXX	Zinc Plate with Yellow Chromate	092-08-0004
092-B08X-XXX	Zinc Plate with Clear Chromate	092-08-0002
092-B09X-XXX	Bright Cadmium Plate	
092-B20X-XXX	Bright Tin Plate (Electroplate)	
092-B21X-XXX	Bright Tin-Lead Plate (Electroplate)	
092-B22X-XXX	Bright Acid Tin Plate	
092-B30X-XXX	Nickel Electroless Plating on Metal Substrates	092-08-0003
092-B35X-XXX	Copper and Nickel Electroplating for Metal Substrates	092-08-0003
092-B40X-XXX	Copper and Nickel Electroless Plating for Plastic Substrates	092-08-0007
092-B45X-XXX	Copper and Nickel Electroplating for Plastic Substrates	None
092-B50X-XXX	Brass Plating	
092-B55X-XXX	Vacuum Deposition of Aluminum Coatings	None

Table 2 (Cont.): Touch-Up Cross Reference List

Finish Number	Finish	Touch-Up Specification
	Conversion and Oxide Coatings	
092-C20X-XXX	Yellow Chromate Conversion Coatings on Aluminum	092-08-0005
092-C21X-XXX	Clear Chromate Conversion Coatings on Aluminum	092-08-0006
092-C22X-XXX	Yellow Chromate Conversion Coatings on Aluminum	092-08-0005
092-C25X-XXX	Surface Preparation for Painting	None
092-C28X-XXX	Yellow Chromate Conversion Coatings for Non-Ferrous Castings	092-08-0005
092-C35X-XXX	Anodizing (Sulfuric) Acid	
092-C36X-XXX	Anodizing (Chromic)Acid	
092-C38X-XXX	Black Anodizing	
092-C39X-XXX	Anodic Hard Coating	
092-C50X-XXX	Black Oxide Coating for Iron	None
092-C60X-XXX	Passivate - for Stainless Steel	None

4 RESPONSIBILITY

It is the responsibility of the applicator to ensure compliance with all applicable local, state, and country regulations pertaining to materials or processes referred to: in this standard; in the applicable specifications; or in the referenced documents. If the materials are considered hazardous, they may be controlled by environmental, health, and safety regulations.

APPENDIX A REFERENCED DOCUMENTS

A.1 EL-Class Digital Documents

EL-Class Number	Document Title
EL-00012-01	*DEC STD 012-1 Documentation Identification Conventions Including Mnemonic Codes*
EL-00092-01	*DEC STD 092-1 Finish and Color Standard - Finish Standard for Applicators*
EL-00092-08-0001	*Touch-Up Procedure for Air-Dry and Aerosol Paints*
EL-00092-08-0002	*Touch-Up Procedure for Zinc Plate and Clear or Blue Bright Chromate*
EL-00092-08-0003	*Touch-Up Procedure for Nickel Plating*
EL-00092-08-0004	*Touch-Up Procedure for Zinc Plate and Yellow Chromate*
EL-00092-08-0005	*Touch-Up Procedure for Yellow Chromate on Aluminum*
EL-00092-08-0006	*Touch-Up Procedure for Clear Chromate on Aluminum*
EL-00092-08-0007	*Touch-Up Procedure for Electroless Nickel Plating on Plastics*

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